



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5068-041
Job Sheet 170723



Part No: D5068-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/18/18

Job Tracking No:

Due Date: 3/23/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: D5068 REV.A IPP REV:A 17.08.30 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Large Fab-7		D.M.L 13-2-15
110	Large Fab	1 pcs	3/22/18	3/22/18	0.00	20.00	Large Fab 1		14 18-02-16
120	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC9		CPC
130	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC5		CPC
140	HandFinish	1 pcs	3/22/18	3/22/18	0.00	0.25	HandFinish2		18-02-22 8
150	Powdercoat	1 pcs	3/22/18	3/22/18	0.00	0.50	Powdercoat2		13 18-02-23
160	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC3		18-02-22
170	HandFinish	1 pcs	3/23/18	3/23/18	0.00	0.25	HandFinish4		14 18-2-22
180	QC	1 pcs	3/23/18	3/23/18	0.00	0.00	QC5		24 18-2-27
190	Packaging	1 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3-2		18-2-27
200	QC21-SA	1 Ea	3/23/18	3/23/18	0.00	0.00	QC21		21 FEB 20 2018

Part Op 110 - 1- Assemble ribs , weld as per dwg D5068 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base

Descriptions: mesh and tack weld all mesh on basket as per dwg D5068 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- Weld hinge (3) and Mounting brackets as per dwg D5068 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

150 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2-Mask this area prior to finish section A-A,

B-B 3-1ST COAT: START TIME: 8:25 OVEN TEMPERATURE: 345° FINISH TIME: 8:40

***** 2nd coat if necessary***** 2ND COAT: START TIME: OVEN

TEMPERATURE: FINISH TIME:

170 - ASSEMBLE BLANKING PLATE AND BUMPER AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	100-Start up Operation	5 033599
D3913-1	Rib	1 Ea (1 ea)	100-Start up Operation	5 032741
D3913-15	Wide Handle Plate	1 Ea (1 ea)	100-Start up Operation	5 034377
D3913-3	Rib	1 Ea (1 ea)	100-Start up Operation	5 032655
D3913-9	Hinge Rib	1 Ea (1 ea)	100-Start up Operation	5 030824
D3916-041	Rib Assembly	2 Ea (2 ea)	100-Start up Operation	5 036892
D3916-5	Light Rib	5037859 x 12 Ea (1 ea)	100-Start up Operation	5 040550
D4016-1	Hinge Half, Base	3 Ea (3 ea)	100-Start up Operation	5 036080
D4017-7	Rib	3 Ea (3 ea)	100-Start up Operation	5 031312
D4020-11	End Mesh, Basket	2 Ea (2 ea)	100-Start up Operation	5 041136
D4021-1	Handle Plate	3 Ea (3 ea)	100-Start up Operation	5 0319317
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	100-Start up Operation	5 039774

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Q Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By 	
				Lead hand / Supervisor Approval Verification 	
				QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Part Specifications			
4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	100-Start up Operation
D4672	Blanking Plate	2 Ea (2 ea)	100-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	100-Start up Operation
D4785-117	Rib Assembly	2 Ea (2 ea)	100-Start up Operation
D5068-1	Rib	2 Ea (2 ea)	100-Start up Operation
D5068-3	Rib	2 Ea (2 ea)	100-Start up Operation
D5068-5	Rib	2 Ea (2 ea)	100-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	170-HandFinish
D2931	Bumper	2 Ea (2 ea)	170-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	170-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	170-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	170-HandFinish
NAS1149DN832J	Washer	2 Ea (2 ea)	170-HandFinish

5039773
5036909
5034149
5039905
50341314
50341268
5034063

5016376

Specifications could not be found.

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order I Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 1270 Aberdeen Street Hamlet, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com Container No: S042687 Part: D5068-041 Serial No/Batch: S042687 Revision: D5068 Inspector:																																																								
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Containers on Master Unit 000923				
Serial No	Part No	Customer Part No	Status	Quantity
S043964	AN3-10A	AN3-10A	Allocated	6
S042664	D2581		Allocated	0
S043965	D2931	D2931	Allocated	2
S042665	D3913-1		Allocated	0
S042666	D3913-15		Allocated	0
S042667	D3913-3		Allocated	0
S042669	D3913-9		Allocated	0
S042670	D3916-041		Allocated	0
S042671	D3916-5		Allocated	0
S034748	D4016-1		Allocated	0
S042673	D4016-1		Allocated	0
S042675	D4017-7		Allocated	0
S042676	D4021-1		Allocated	0
S042678	D4034-041		Allocated	0
S042679	D4034-043		Allocated	0
S042681	D4672-1		Allocated	0
S039425	D4785-117		Allocated	0
S042686	D5068-1		Allocated	0
S042682	D5068-3		Allocated	0
S042685	D5068-5		Allocated	0
S042683	M304EX0.75-16F		Allocated	0.14
S043967	MS20600-AD4W3		Allocated	2
S043968	MS21042L3	MS21042L3	Allocated	6
S043970	NAS1149DN832J	NAS1149DN832J	Allocated	2
S043971	NAS1149F0332P		Allocated	12